

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009836**Date Inspected:** 18-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Bing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

Trial Assembly-

This QA Inspector observed the following work in progress: Air Carbon Arc Gouging of Bike Path Cantilver beam BK001 for panel point 29. The beam located on the ground outside Segment 1W for repair.

ZPMC grinding floor beam and bottom panel base material after longitudinal diaphragm removal at panel point 32 on bike path side. Base metal excavations up to 5 mm were found on the floor beam and bottom panel base material.

Several small areas of repair were observed on 5BW to 5CW deck panel transverse splice weld. Repair areas were noted in the temporary attachment removal areas and the weld as well intermittently for the full length of the weld. Repair areas were also noted for areas marked as undercut on the deck panel I ribs and edge plate hold back welds.

Bay 9-

This Caltrans QA Inspector performed Magnetic Particle Testing verification of OBG Deck Panel DP3045-001-001 through 010 and DP 3031-001-001 through 008 tack welds after ZPMC initial MT inspection. ZPMC personnel have made repairs of areas found unacceptable. ZPMC has not performed the final MT of the

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repair areas. No relevant indications were found during inspection. This is considered an in process verification and a TL-6028 report was not generated for the above mentioned verification.

Bay 11:

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of East Tower Lift 4 diaphragm to skin plate 'D' weld joint, ESTL4-2 F/L-131, located on the 127 meter double diaphragm top plate. ZPMC welder was identified as 042218. ZPMC QC is identified as Wang Bing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4332-TC-P4-F.

Flux Cored Arc Welding (FCAW) of East Tower Lift 4 diaphragm to skin plate 'D' weld joint, ESTL4-2 H/L-131, located on the 127 meter double diaphragm top plate. ZPMC welder was identified as 042218. ZPMC QC is identified as Wang Bing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4332-TC-P4-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation occurred between QC and QA this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

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| Inspected By: | Viars,Larry | Quality Assurance Inspector |
| Reviewed By: | Dawson,Paul | QA Reviewer |
